

Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claims 1-50 (cancelled)

1 Claim 51 (currently amended): A method for manufacturing  
2 products ~~(1,30,40)~~ in a mold, said products comprising a  
3 first and second mass comprising at least natural polymers,  
4 wherein said products are manufactured by bringing masses  
5 into or through a mold ~~(60, 70, 80)~~ which are heated within  
6 said mold, such that this involves at least cross-linkage of  
7 the natural polymers, while of at least one first part ~~(6,~~  
8 ~~36,85)~~ of the product ~~(1, 30, 40)~~, the material composition  
9 is influenced such that the material properties of the  
10 relevant first part ~~(6, 36, 85)~~ deviate from the material  
11 properties of parts adjoining said part, wherein as masses  
12 at least a first mass (M1) and a second mass (M2) are used  
13 ~~wherein the first mass (M1) and a second mass (M2) are used~~  
14 ~~wherein the first mass (M1) differs in composition from the~~  
15 ~~second mass (M2) prior to introduction into or through said~~  
16 ~~mold 60, 70, 80)~~ and wherein the at least one first part ~~(6,~~  
17 ~~36,85)~~ of the product ~~1, 30, 40)~~ is formed from said second  
18 mass (M2) and at least one part ~~(2, 4, 32, 36, 87, 89, 48)~~  
19 adjoining the relevant first part ~~(6, 36, 85)~~ are is formed  
20 of said first mass (M1).

1 Claim 52 (currently amended): A method according to  
2 claim 51, wherein at least one of said at least one first  
3 part ~~(6, 36, 85)~~ in the mold is formed such that a relatively  
4 high concentration of softener is obtained and/or maintained  
5 herein, such that the flexibility of the relevant at least  
6 one front part ~~(6, 36, 85)~~ is greater than the flexibility of  
7 parts ~~(2, 4, 32, 36, 87, 89, 48)~~ adjoining said part.

1 Claim 53 (currently amended): A method according to  
2 claim 51, wherein the second mass is selected from the group  
3 consisting of masses of relatively much softener and/or  
4 softener retaining components compared to said first mass  
5 (M1) such that after the manufacture of the product, so much  
6 softener or softener of such nature remains behind in the  
7 relevant first part ~~(6, 36, 85)~~ that the pliability thereof  
8 is greater than the pliability of wall parts of parts ~~(2, 4,~~  
9 ~~32, 36, 48, 87, 89)~~ adjoining said part made of said second  
10 mass.

1 Claim 54 (currently amended): A method according to  
2 claim 51, wherein the second mass is selected from the group  
3 of masses consisting of relatively little softener or  
4 softener retaining components compared to said first mass  
5 (M1), such that after the manufacture of the product, such  
6 small amount of softener or softener of such mature remains  
7 behind in the relevant first part ~~(6, 36, 85)~~ that the  
8 brittleness of at least a part thereof is greater than that  
9 of wall parts ~~(2, 2, 32, 36, 48, 87, 89)~~ adjoining said part  
10 made of said first mass (M1).

1 Claim 55 (currently amended): A method according to  
2 claim 51, wherein the first and second masses are selected  
3 from the groups of masses consisting of different types  
4 and/or amounts of fibers, the second mass being selected  
5 such that after the manufacture of the product, a  
6 concentration and/or orientation of fibers is obtained  
7 and/or type of fibers is included in the relevant first part  
8 ~~(3, 36, 85)~~ which deviates from the concentration,  
9 orientation and/or nature of any fibers present in other  
10 parts ~~(2, 4, 32, 36, 48, 87, 89)~~.

1 Claim 56 (currently amended): A method according to  
2 claim 51, wherein the first and second masses are selected  
3 from groups of masses consisting of different types and/or  
4 amounts of blowing agents and/or fillers, the second mass  
5 being selected so that at least during the manufacture of  
6 the product, a concentration of and/or type of blowing agent  
7 and/or filler is obtained in the relevant first part ~~(6, 36,~~  
8 ~~85)~~ which deviates from that in other parts ~~(2, 4, 32, 36,~~  
9 ~~48, 87, 89)~~ of the product, to obtain a product in which, in  
10 the relevant first part ~~(6, 36, 85)~~, a structure is realized  
11 whose density deviates from the density of other parts ~~(2,~~  
12 ~~4, 32, 36, 48, 87, 89)~~ of the product.

1 Claim 57 (currently amended): A method according to  
2 claim 51, wherein the first and second masses are selected  
3 from groups of masses consisting of different types and/or  
4 amounts of colorants, wherein the second mass is selected so  
5 that in the relevant first part ~~(6, 36, 85)~~, a concentration  
6 of and/or a type of colorant is obtained which deviates from  
7 that in other parts ~~(2, 4, 32, 36, 48, 87, 89)~~ of the  
8 product, to obtain a product in which the relevant first

9 part ~~(6, 36, 85)~~ has a color deviating from that of other  
10 parts ~~(2, 4, 32, 36, 48, 87, 89)~~ of the product.

1 Claim 58 (currently amended): A method according to  
2 claim 51, wherein the first and second masses are selected  
3 from groups of masses consisting of different types and/or  
4 concentrations of cross linkers, wherein the second mass is  
5 selected so that at least during the manufacture of the  
6 product, a concentration of and/or a type of cross-linkers  
7 is obtained in the relevant first part ~~(6, 36, 85)~~, a  
8 concentration of and/or a type of cross-linkers is obtained  
9 which deviates from that in other parts ~~(2, 4, 32, 36, 48,~~  
10 ~~87, 89)~~ of the product, to obtain a product in which the  
11 relevant first part ~~(6, 36, 85)~~ has a structure whose  
12 density deviates from the density of other parts ~~(2, 4, 32,~~  
13 ~~36, 48, 87, 89)~~ of the product.

1 Claim 59 (previously presented): A method according to  
2 claim 51, wherein the second mass is introduced between two  
3 flows of first mass.

1 Claim 60 (currently amended): A method according to  
2 claim 51, wherein the second mass is introduced into a mold  
3 in a zone forming the relevant first part ~~6, 36, 85)~~ while  
4 the first mass is introduced into a number of zones forming  
5 parts ~~(2, 4, 32, 36, 48, 87, 89)~~ adjoining said first zone,  
6 such that in the closed mold, the first mass and the second  
7 mass are forced against each other and interconnected.

1 Claim 61 (previously presented): A method according to  
2 claim 51, wherein the first and second mass in the mold are  
3 interconnected prior to or at least at the start of the  
4 occurrence of cross-linkage of the natural polymers.

1 Claim 62 (previously presented): A method according to  
2 claim 51, wherein the first mass and the second mass are  
3 introduced into the mold out of phase, while preferably the  
4 introduction of the second mass is started prior to the  
5 introduction of the first mass.

1 Claim 63 (previously presented): A method according to  
2 claim 51, wherein the first mass in the mold is subjected to  
3 a first pressure and the second mass in the mold is  
4 subjected to a second pressure, the first pressure deviating  
5 from the second pressure.

1 Claim 64 (previously presented): A method according to  
2 claim 51, wherein the or each mass is introduced into the  
3 mold under a pressure higher than atmospheric, preferably  
4 through injection molding.

1 Claim 65 (previously presented): A method according to  
2 claim 51, wherein at least three different masses are used  
3 for the manufacture of the product.

1 Claim 66 (currently amended): A method according to  
2 claim 51, wherein at least the at least one first part ~~(6,~~  
3 ~~36, 85)~~, after formation in the mold, is processed such that  
4 the material properties of said relevant first part ~~(6, 36,~~  
5 ~~85)~~, are changed, at least relative to parts ~~(2, 4, 32, 36,~~  
6 ~~48, 87, 89)~~ adjoining said part ~~(6, 36, 85)~~.

1 Claim 67 (currently amended): A method according to  
2 claim 51, wherein at least a portion of the at least one  
3 first part ~~(6, 36, 85)~~, a first coating is applied, said  
4 coating comprising at least a component active with the  
5 relevant first mass, such that between the relative active  
6 component and the mass, there is obtained a reaction whereby  
7 the material properties of the relevant first part ~~(6, 36,~~  
8 ~~85)~~ are influenced.

1 Claim 68 (currently amended): A method according to  
2 claim 67, wherein at least the parts ~~(2, 4, 32, 36, 48, 87,~~  
3 ~~89)~~ adjoining the first part ~~(6, 36, 85)~~ are covered prior  
4 to the application of the first coating.

1 Claim 69 (currently amended): A method according to  
2 claim 68, wherein at parts ~~(2, 4, 32, 36, 48, 87, 89)~~  
3 adjoining the first part ~~(6, 36, 85)~~ are at least partially  
4 covered by a second coating, substantially impermeable to  
5 said reactive component of the first coating, such that the  
6 first part ~~(6, 36, 85)~~ is at least partially kept clear of  
7 the second coating.

1 Claim 70 (previously presented): A method according to  
2 claim 69, wherein a second coating is used having a high  
3 hardness relative to the first coating, a relatively low  
4 permeability and high resistance to at least said reactive  
5 component.

1 Claim 71 (previously presented): A method according to  
2 claim 69, wherein the first coating is applied over the  
3 second coating.

1 Claim 72 (previously presented): A method according to  
2 claim 67, wherein as first coating, a water based coating is  
3 used.

1 Claim 73 (previously presented): A method according to  
2 claim 67, wherein as first coating, a relatively flexible  
3 elastic coating is used.

1 Claim 74 (previously presented): A method according to  
2 claim 67, wherein as first coating, a coating is selected  
3 from the group consisting of acrylic binders, lattices,  
4 styrene-butadiene latex, polyvinyl alcohol, polyvinyl  
5 acetate, polyacrylates, polyethylene glycol, polylactic acid,  
6 synthetic polymers, natural polymers, natural waxes,  
7 synthetic waxes (for instance polyethylene waxes) or  
8 derivatives thereof or combinations of the preceding.

1 Claim 75 (previously presented): A method according to  
2 claim 69, wherein as second coating, a coating is used  
3 comprising a number of constituents from the group  
4 consisting of: melamine, acrylic binders, water resistant  
5 lacquers (for instance cellulose lacquer), cellulose acetate  
6 propionates, polyethylene, polyacrylates, synthetic  
7 polymers, natural polymers, synthetic waxes, natural waxes,  
8 polyactic acid, derivatives thereof or combinations of the  
9 preceding.

1 Claim 76 (previously presented): A method according to  
2 claim 74, wherein cross-linkers are incorporated into the  
3 first and/or second coating, in particular selected from the  
4 group consisting of zirconium acetate, ammonium zirconium  
5 carbonate, urea formaldehyde, melamine formaldehyde,

6 glyoxal, polyamideamine-epichlorohydrin, epoxides,  
7 trimetaphosphate, derivatives thereof or combinations of the  
8 preceding.

1 Claim 77 (previously presented): A method according to  
2 claim 74, wherein in the first coating, at least one of the  
3 waxes is combined with at least one of the said other  
4 constituents.

1 Claim 78 (previously presented): A method according to  
2 claim 74, wherein the first, respectively second coating is  
3 formed almost entirely from one of said constituents.

1 Claim 79 (currently amended): A method according to  
2 claim 51, wherein the first part ~~(6, 36, 85)~~ is designed as  
3 a hinge part 6 having at least one recess, in particular at  
4 least one groove extending over the width of the hinge part.

1 Claim 80 (currently amended): A method according to  
2 claim 51, wherein into the first part ~~(6, 36-85)~~, after  
3 cross-linking of the natural polymers, a softener is  
4 introduced.

1 Claim 81 (currently amended): A method according to  
2 claim 51, wherein a reactive component is incorporated into  
3 the first part ~~(6, 36, 85)~~, outside the mold, while ~~it~~said  
4 reactive component is at least substantially prevented from  
5 flowing away to the other parts, ~~preferably a softener~~  
6 ~~having a relatively large particle size and/or high~~  
7 ~~viscosity.~~



1 Claim 82 (previously amended): A method according to  
2 claim 81, wherein as reactive component, at least a fatty,  
3 oily or waxy ingredient is used.

1 Claim 83 (previously presented): A method according to  
2 claim 51, wherein the softener is selected from the group  
3 consisting of water, polyols, glycol, glycerol, glycerin,  
4 polyethylene glycol, polypropylene glycol, propylene glycol,  
5 sorbitol, glucose derivatives thereof or combinations of  
6 preceding softeners.

1 Claim 84 (previously presented): A method according to  
2 claim 51, wherein at least during a portion of the  
3 cross-linking of the natural polymers, the first part is at  
4 least partially compressed.

1 Claim 85 (previously presented): A method according to  
2 claim 51, wherein in or on at least the first part, an  
3 active component is provided for adjusting the surface  
4 tension of at least said first part of the product with  
5 cross-linked natural fibers, in particular for increasing  
6 the surface tension.

1 Claim 86 (previously presented): A method according to  
2 claim 51, wherein to at least a part of the product, a  
3 coating is applied whose surface tension is approximately  
4 equal to or lower than the surface tension of the product  
5 part to which the coating is applied.

1 Claim 87 (previously presented): A method according to  
2 claim 51, wherein a coating is applied to the product, said  
3 coating comprising cross-linkers for the mass, in particular  
4 natural polymers incorporated therein.

1 Claim 88 (previously presented): A method according to  
2 claim 51, wherein at least two coatings are applied at least  
3 partially one over the other, at least one of the coatings  
4 comprising an active component capable of reacting with the  
5 at least one other coating.

1 Claim 89 (previously presented): A method according to  
2 claim 88, wherein as active component, at least  
3 cross-linkers are used.

1 Claim 90 (currently amended): A method according to  
2 claim 67, wherein the product is gripped at the first part  
3 ~~(6, 36, 85)~~, such that it is covered at least substantially  
4 completely, after which the second coating is applied to  
5 other parts ~~(2, 4, 32, 36, 48, 87, 89)~~, in particular  
6 sprayed thereon, after which the first part is released and,  
7 after that, the second coating is applied, in particular  
8 sprayed thereon.

Claims 91-100 (cancelled).